

Date: Monday, 06/10/2008 1:20:16 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WHEEL ASSEMBLY
Job Number : 42464	
Estimate Number : 12099	
P.O. Number :	Part Number : D3233041
This Issue : 06/10/2008 S.O. No. :	Drawing Number : D3233 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 37638	Material :
Written By :	Due Date : 20/10/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 08-10-06</u>	
Comment : Est. C 05.07.18 D3233-5 was D3332-5; Qty changed by half K J/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D32335	Hub Sleeve
✓		
Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Hub Sleeve Pick: Qty Part Number Description Batch 1 D3233-5 Hub Sleeve <u>B37647</u> <u>SAD</u> <u>08/11/03</u> <u>6</u>		
2.0	D32337	Shaft Sleeve
✓		
Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Shaft Sleeve Pick: Qty Part Number Description Batch 1 D3233-7 Shaft Sleeve <u>B37648</u> <u>SAD</u> <u>08/11/03</u> <u>6</u>		
3.0	D32339	Tire & Rim Assembly
✓		
Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Tire & Rim Assembly Pick: Qty Part Number Description Batch 1 D3233-9 Tire & Rim Assembly <u>B37649</u> <u>SAD</u> <u>08/11/03</u> <u>6</u>		
4.0	NKI 3020	BEARING
✓		
Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Bearing Pick: Qty Part Number Description Batch 2 NKI 30/20 Bearing & Inner Sleeve <u>M102135</u> <u>SAD</u> <u>08/11/03</u> <u>6</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WHEEL ASSEMBLY

Job Number: 42464

Part Number: D3233041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SHIM STOCK

.004" Brass Shim Stock



* Comment: Qty.: 4.0000 f(s)/Unit Total: 24.0000 f(s)

.004" Brass Shim Stock

Pick:

Qty Part Number Description

Batch

4 Shim Stock 0.004" thick Brass Shim Stock

M102/30

SAD 08/11/03

(6)

6.0

35X45X7

Bearing Seal



✓ Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bearing Seal

Pick:

Qty Part Number Description Batch

2 35x45x7 Axel Seal

M107280 → 3

or CR 35x45x7 HMS4 R

M109645 → 9

SAD 08/10/27

(6)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Press out bearings that are supplied with D3233-9 wheel and discard them.

Cut shims and assemble as per Dwg D3233

Spray inside hub and bearing with LPS-3 & block hole with a clean dry rag for storage.

SAD 08/10/03

(6)

8.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-03 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

NO ORIGIN 5 BURR LINDA 08/11/03 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/04 (6)

Job Completion



mf 08-11-03

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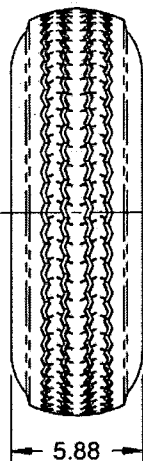
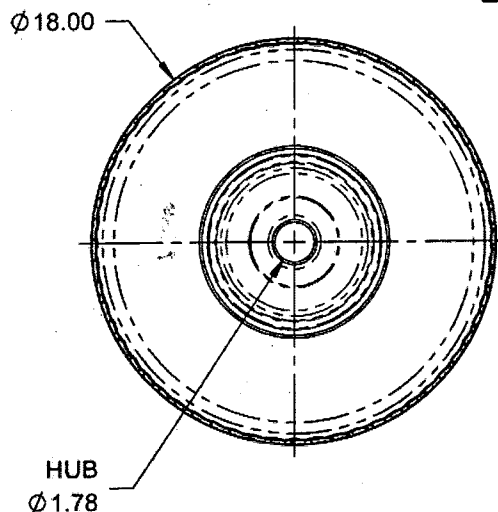
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NOTE: Date & initial all entries



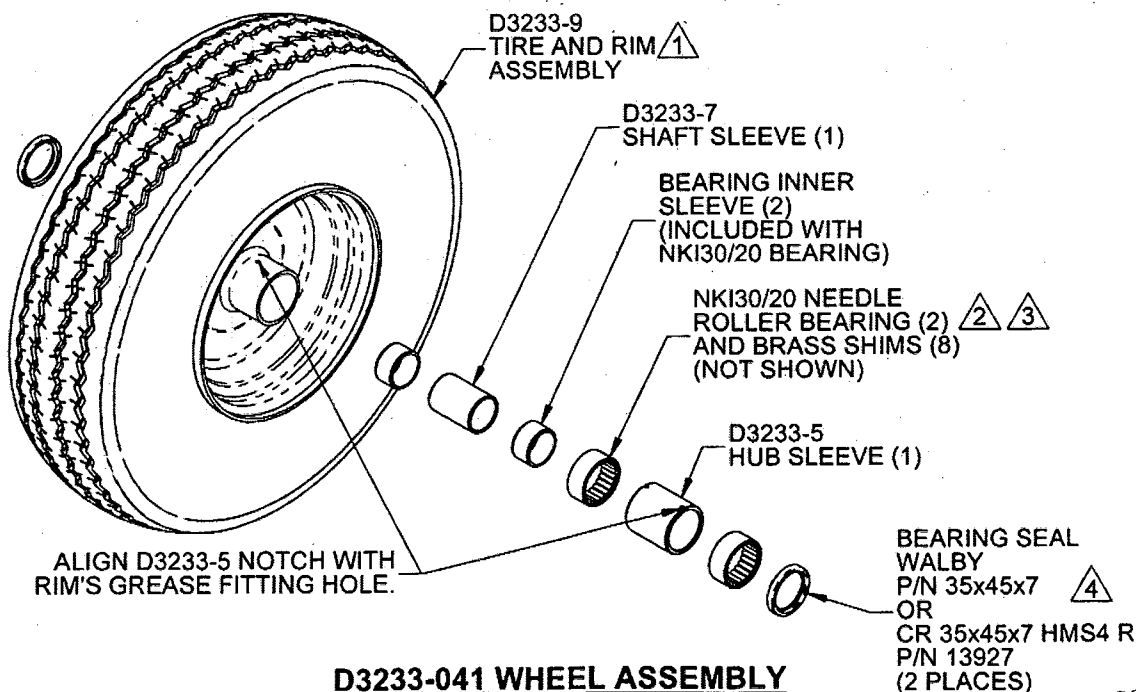
DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMENDATIONS
ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

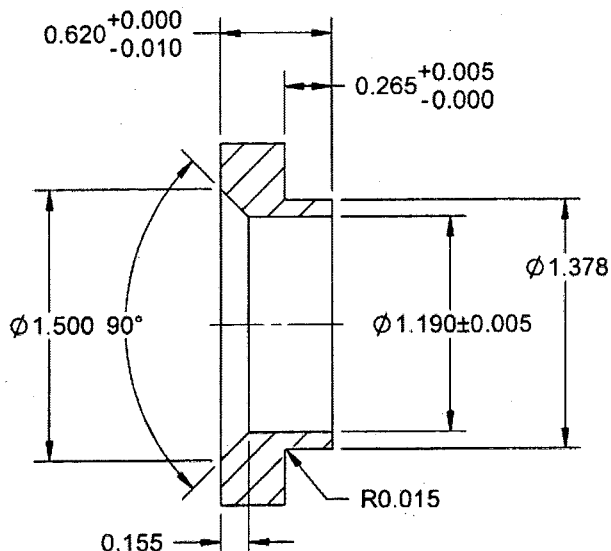
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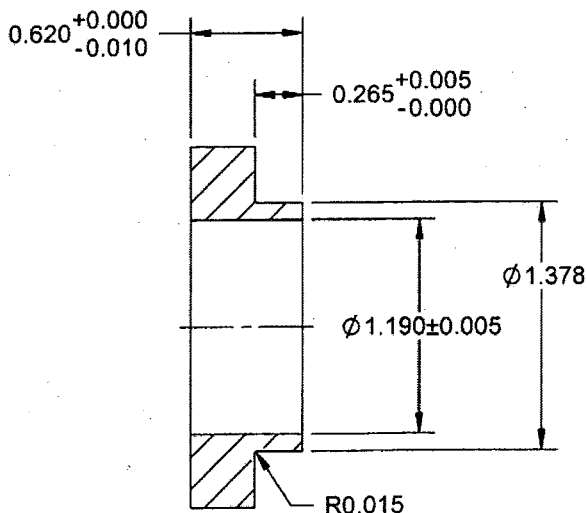
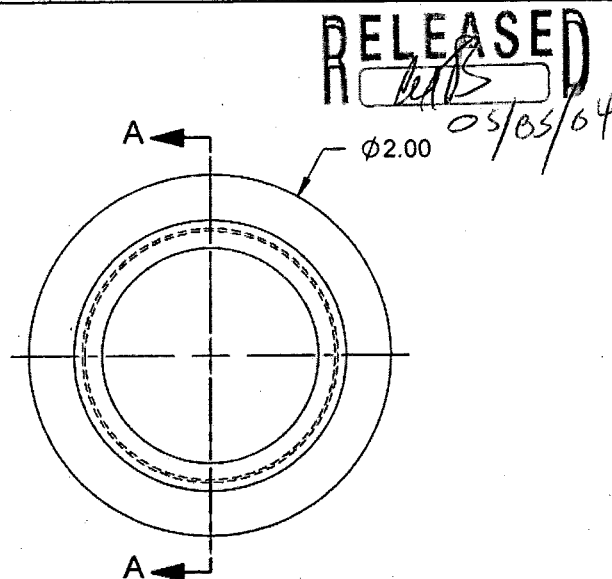


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



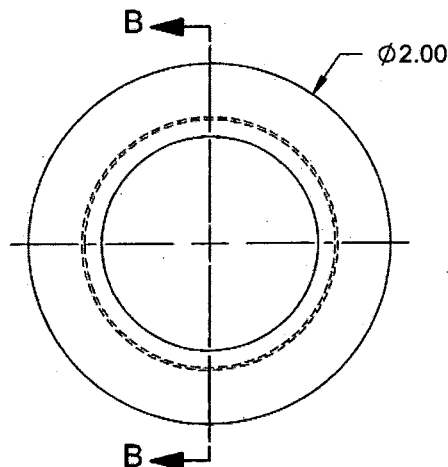
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00, MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

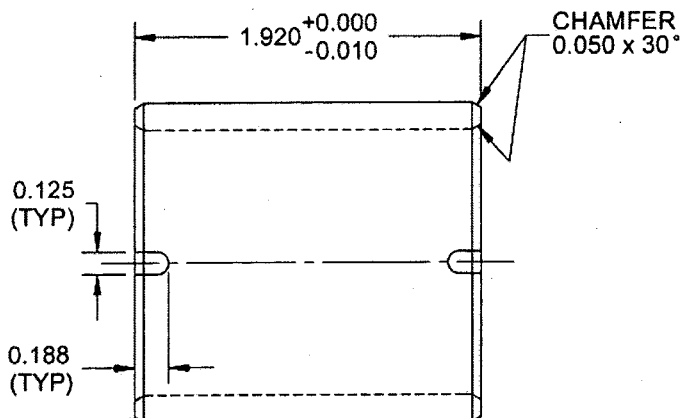
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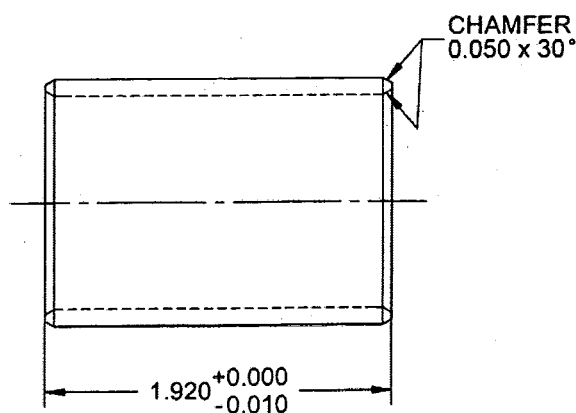
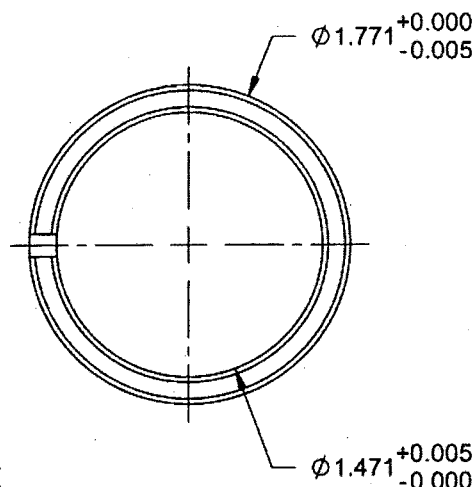


DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R	APPROVED WBS	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

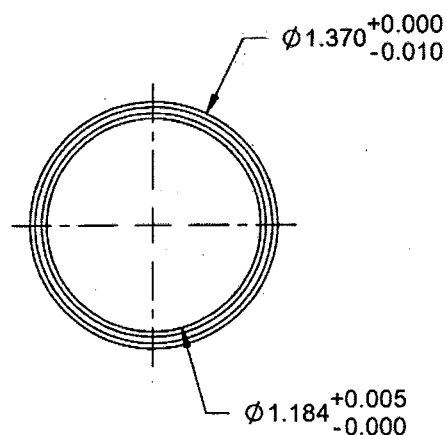
RELEASED
WBS
05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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